

Date: Wednesday, 9/12/2007 12:13:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPRING	
Job Number	: 34590		Part Number	: D2535	
Estimate Number	: 10497		Drawing Number	: D2535 REV. A	
P.O. Number	:		Project Number	: N/A	
This Issue	: 9/12/2007	S.O. No. :	Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type :	Due Date	: 10/10/2007	
Previous Run	: 31486		Qty:	20 Um: Each	
Written By	:		SO V		
Checked & Approved By	:		20		
Comment	: Est. A 99.04.19		New Issue (From hand written IPP) DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING 4580 Issue P/O: <u>4580</u> Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring
2.0	D2535P	Spring
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) SPRING
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Check dims to dwg
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>st 36</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 34590

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



01.10.02 *JK*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 01.10.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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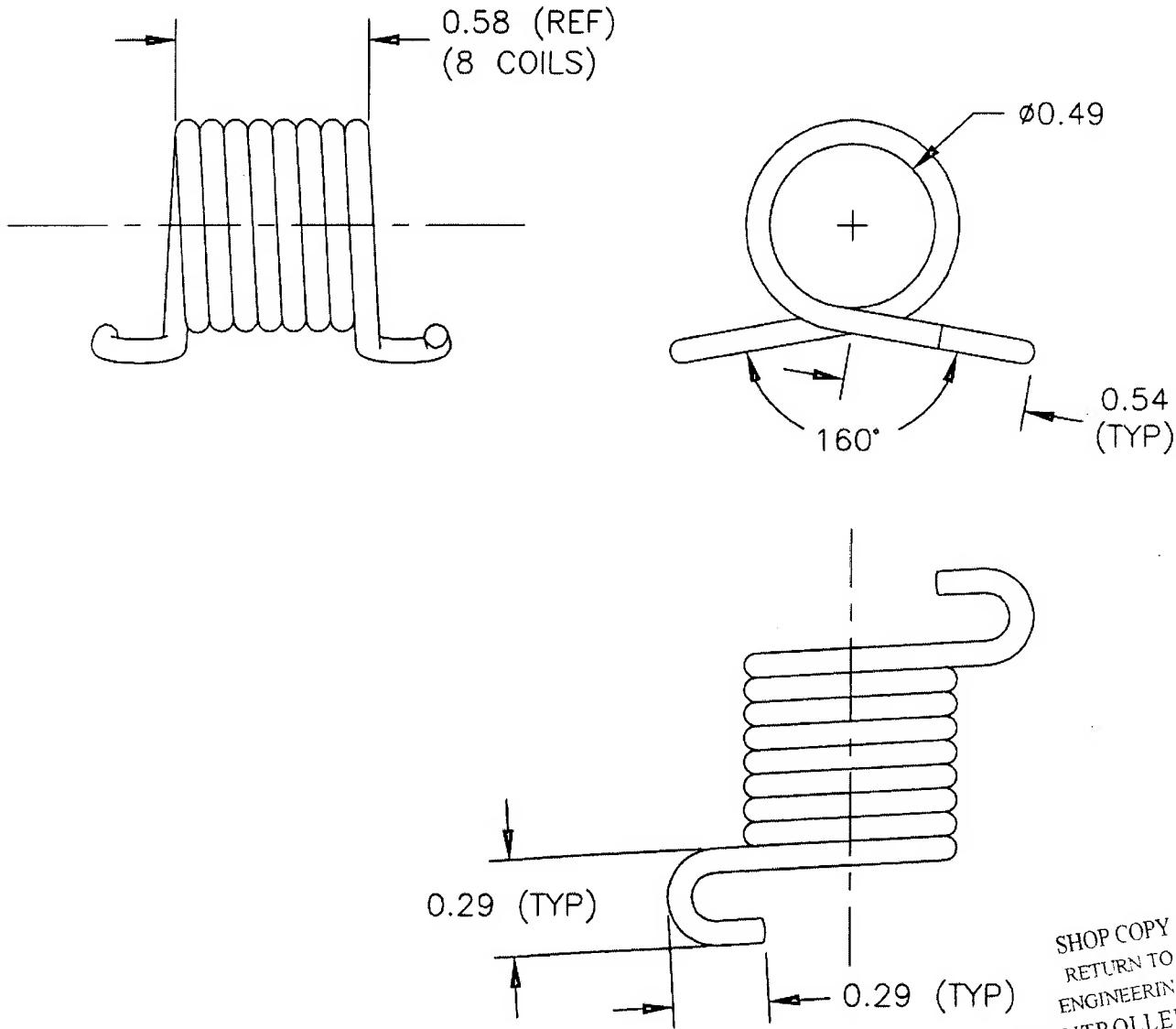
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED DHF	DRAWING NO. D2535
DATE 99.04.08	TITLE SPRING SPEC CONTROL	REV. A SHEET 1 OF 1 SCALE 2:1

RELEASED
99.05.11 KE

A 99.04.08 NEW ISSUE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34590

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL Ø0.070

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Victory Spring Ltd.

INVOICE 17490

#2 6104 - 82 Ave, Edmonton, AB T6B 0E7
Tel: (780) 442-4020 • Fax: (780) 468-1946

PRECISION COIL SPRINGS AND WIRE FORMS

BILL TO:
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

SHIP TO:

DATE	ORDER NO.	SHIP VIA	
25-Sep-07	4580	Fed Ex 151793240	
QUANTITY	DESCRIPTION	UNIT	AMOUNT
50	D2535 Torsion Spring	4.50	225.00
GST #	TERMS	SUBTOTAL	FREIGHT
854 154527	NET 30 DAYS	225.00	13.50
			TOTAL
			238.50

Victory Spring Ltd.

CONFORMANCE REPORT

#2, 6104 - 82 Ave, Edmonton, AB T6B 0E7
Tel (780) 442-4020 Fax: (780) 468-8000

REPORT FOR: Dart Aerospace Ltd		DATE: 9/25/2007
PO # 4580	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: Torsion Spring		QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	.070"	Yes	
I.D.	.490"	.495"	
O.D.			
Number of Coils	8 Ref.	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per drawing	Yes	
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: No
Material Heat Number: NA

Certified by: Jeremy Burrowes